



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3914-041
Job Sheet 167247-B



Part No: D3914-041

Job Qty: 1 ea

Part Name: Long Basket Lid Assembly (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 11/17/17

Created By: Mario Poulin

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/16/17	0.00	0.00	Start Up Large Fab2		✓ 17-12-19
100	Large Fab	1 pcs		11/16/17	0.00	6.67	Large Fab 1		✓ 17-12-19
110	QC	1 pcs		11/16/17	0.00	0.00	QC9		✓ 17-12-22
120	QC	1 pcs		11/16/17	0.00	0.00	QC5		✓ 17-12-22
130	Powdercoat	1 pcs		11/16/17	0.00	0.40	Powdercoat4		✓ 17-12-28
135	QC	1 pcs		11/16/17	0.00	0.00	QC3		✓ 18-01-01
140	HandFinish	1 pcs		11/17/17	0.00	0.80	HandFinish3		✓ 18-01-11
150	QC	1 pcs		11/17/17	0.00	0.00	QC3		✓ 18-01-11
160	Packaging	1 pcs		11/17/17	0.00	0.00	Packaging3		✓ 18-01-11
170	QC21-SA	1 Ea		11/17/17	0.00	0.00	QC21		DAS JAN 11 2018

Part Op 100 - 1- assemble ribs , weld as per dwg D3914 using DT9607A 2- weld hinge (3) and Mounting brackets as per dwg
Descriptions: D3914 ***Visual inspect before welding mesh*** 3- tack weld mesh on basket as per dwg D3914 ***Cut out mesh where
label plate goes in center off basket lid as per dwg D4020-5. Make sure to place mesh correctly on lid, check with label
plate before tacking mesh***
130 - *** mask sides of hinge prior to powdercoat***
140 - 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install label as per dwg ***Mask
label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

177 135418 START: 11:30 O.V.T: 3:20 FINISH: 12:00.

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2581 8005842	2	16	0	0
	D3914-1 8011790	2	6	0	0
	D3914-7 8010143	2	10	0	0
	D4016-3 8010799	3	19	0	0
	D4018-5 8011651	9	45	0	0
	D4020-5 8019928	1	8	0	0
	D4021-3 8007083	1	7	0	0
	D4035-043 8017242	2	0	0	0
140-HandFinish	D2728-3	1	0	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Work Order

Part

NCR

Date :



Long Basket Lid Assembly (350)

PART NO: D3914 – 041
Revision:
Operation: Start up Operation
Change No:

Dart Aerospace Ltd.
 1270 Aberdeen Street
 Hawkesbury, ON K64 1K7
 CANADA
 TEL.: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Work Order update only ☐

AGAINST DEPARTMENT/PROCESS

Loss tube	☐	Water Jet	☐	Engineering	☐
Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Composite	☐	Supplier	☐		

MRB (QSI042) Approval

Disposition

Completed By

Lead hand / Supervisor
Approval Verification

QC / QA Coordinator
Approval

Root Cause

Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

FAULT CATEGORY

Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐

OTHER :

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D3914-041 Revision: Long Basket Lid Assembly (350)														
170	QC21-SA	S025141	167247-B	1 Ea	0	S025141	PKG	Bin	Stock	12/19/2017	Issue Container			
Operation Totals:		1		1	0									
Part Totals:		1		1	0									
Part Number: D4016-3 Revision: Hinge Half, Lid														
170	QC21-SA	S025100	167247-B	0 Ea	0	S010799	WA004	Bin	Stock	12/19/2017	Issue Container			
Operation Totals:		1		0	0									
Part Totals:		1		0	0									
Totals:		2		1	0									